

Work Order ID 72340

Friday, July 22, 2011 2:20:02 PM



Page 1

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 7/22/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 11/07/22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	Rev E								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 72340 Double check by: *SK/ML* ☒ 1-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets ☐ 2-Machine Step
No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine
Step No 3 per Folio FA051 and inspect

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572.

120

0.00



QC- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72340

Friday, July 22, 2011 2:20:02 PM



Item ID: D2571	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle, Fwd Out 205					
Start Date: 7/22/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 8/5/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		h A 11/08/22		12	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

12 X 0 m-l 11/08/22

12 X 0 m-l 11/08/22

START TIME: 10:50
FINISH TIME: 11:20
OVEN TEMPERATURE:

W117745 3200F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72340

Friday, July 22, 2011 2:20:02 PM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 7/22/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BL 11-7-22

170

Identify as per dwg & Stock Location: 433

0.00



Packaging

Memo

0.00

Packaging

SL

K 9/11/08/22

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/22 JF

11/8/22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, July 22, 2011 2:20:08 PM

Page 1

Work Order ID: 72340

Parent Item: D2571

Parent Item Name: Saddle, Fwd Out 205



Start Date: 7/22/2011

Required Date: 8/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-007

Manufactured

No

100

Each

23.0000

1

12



Saddle Billet



22-11-08-15

Location

Loc Qty

Loc Code

MAT045

23

65383

1

65954

4

70680

18

72228

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 72340
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.001	8.002		
F	0.490	0.510		.502	.502	.501	.500		
G	0.257	0.262		.257	.258	.257	.257		
H	0.375	0.380		.376	.377	.376	.376		
I	0.490	0.510		.500	.500	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.123	.125	.123	.123		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.126	.127	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.240	.236	.238		
W	0.115	0.135		.123	.120	.120	.120		
X	0.308	0.313		.310	.310	.311	.311		
Y	0.760	0.765		.762	.760	.760	.760		
Z	0.352	0.372		.362	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.249	.248	.247		
AE	1.375	1.395		1.385	1.385	1.387	1.388		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.260	.250	.260	.260		
AH	0.240	0.260		.251	.251	.246	.247		
AI	2.000	2.020		2.000	2.003	2.003	2.004		
AJ	0.023	0.043		.033	0.033	.033	.033		
Accept/Reject									

Measured by: SL
Date: 11-08-15

Audited by: S.A.
Date: 11/08/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684,	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	22340
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.7500	1.7500	1.750	1.750		
E	7.990	8.010		8.002	8.004	8.002	8.001		
F	0.490	0.510		.502	.503	.502	.503		
G	0.257	0.262		.257	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.502	.500	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.560	.568	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.123	.123	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.250	.250		
S	0.115	0.135		.125	.125	.130	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.240	.240	.240		
W	0.115	0.135		.119	.119	.117	.120		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.780	.760	.760		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.628	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.242	.248		
AE	1.375	1.395		1.387	1.387	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.255	.250	.260		
AH	0.240	0.260		.246	.248	.250	.250		
AI	2.000	2.020		2.004	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>SL</i> / <i>me</i>
Date:	11-08-16

Audited by:	<i>HA</i>
Date:	11/08/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>me</i>

DART AEROSPACE LTD		Work Order: 72340
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505	3.500	3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.002		
F	0.490	0.510		.503	.505	.502	.505		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.377	.377	.377		
I	0.490	0.510		.502	.502	.506	.506		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.871	3.871	3.872		
P	0.115	0.135		.123	.124	.124	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.252	.251		
S	0.115	0.135		.127	.126	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.958	2.958		
V	0.230	0.250		.240	.236	.236	.237		
W	0.115	0.135		.122	.119	.119	.119		
X	0.308	0.313		.310	.311	.310	.311		
Y	0.760	0.765		.760	.760	.760	.761		
Z	0.352	0.372		.365	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.626	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.247	.248	.247		
AE	1.375	1.395		1.387	1.388	1.388	1.387		
AF	0.115	0.135		.125	.135	.132	.135		
AG	0.240	0.280		.255	.255	.260	.265		
AH	0.240	0.260		.250	.246	.246	.247		
AI	2.000	2.020		2.003	2.003	2.004	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	mx
Date:	11/08/19

Audited by:	B.A
Date:	11/08/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries